

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021283**Date Inspected:** 21-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 2100**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Xian Quan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

OBG Segment 13AE / Bay 14

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as OBG Segment 13AE welds as per ZPMC notification # 08256.

The weld designations reviewed are as follows:

SEG3007AX-045, 047

SEG3007B-079

SEG3007D-163, 164

SEG3007AU-114

SEG3007AV-017

SEG3007E-158, 159

SEG3007C-193

OBG Segment 13BE / Bay 14

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This QA Inspector observed the following work in progress:

Sub Arc Welding (SAW) in the 1G position of DP3091A to DP3092A weld # SEG3009-007. The welder is identified as 058100. ZPMC Quality Control (QC) is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2. See attached photograph Pic_001.

OBG Segment 13AE / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of weld # SEG3007AU-103. The welder is identified as 037723. ZPMC Quality Control (QC) is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

OBG Segment 13AE / Bay 14

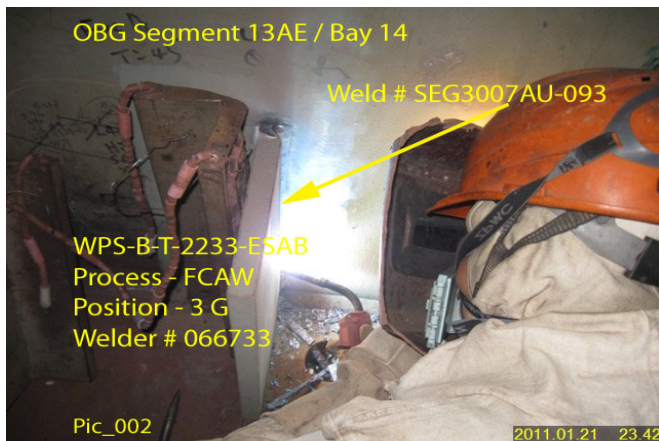
This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of weld # SEG3007AU-093. The welder is identified as 066733. ZPMC Quality Control (QC) is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB. See attached photograph Pic_002.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of repair weld # SEG3019BB-037, as per B-CWR # 2737. The welder is identified as 215553 and 216086. ZPMC Quality Control (QC) is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-FCM-Repair-1.



Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials

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for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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